

Date: Wednesday, 2/15/2006 3:50:15 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---|--|-----------------------|--|-----------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SADDLE FITTING, FWD (OUTBOARD/INBOARD) | | |
| Job Number | : 25859 | | | Part Number | : D2571 | |
| Estimate Number | : 10530 | | | Drawing Number | : D2571 REV D/E | |
| P.O. Number | : N/A | | | Project Number | : N/A | |
| This Issue | : 2/15/2006 | | S.O. No. : N/A | Drawing Revision | : D/E | |
| Prsht Rev. | : NC | | | Material | : N/A | |
| First Issue | : N/A | | Type : MACHINED PARTS | Due Date | : 3/12/2006 | |
| Previous Run | : 25829 | | | Qty: | 6 Um: Each | |
| Written By | : See comment below | | | | | |
| Checked & Approved By | : J.L. 06.02.16 | | | | | |
| Comment | : Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | D6101007 | 7075-T7351 8.25X7.75X2.5 | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B24093 X 6 | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: B25857 Double check by: J.L. | |
| | | 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE | |
| | | Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25859

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 0603.26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/28 (6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 178

DC 06/03/29 (6)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/30 (6)

Job Completion



DC 060329

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

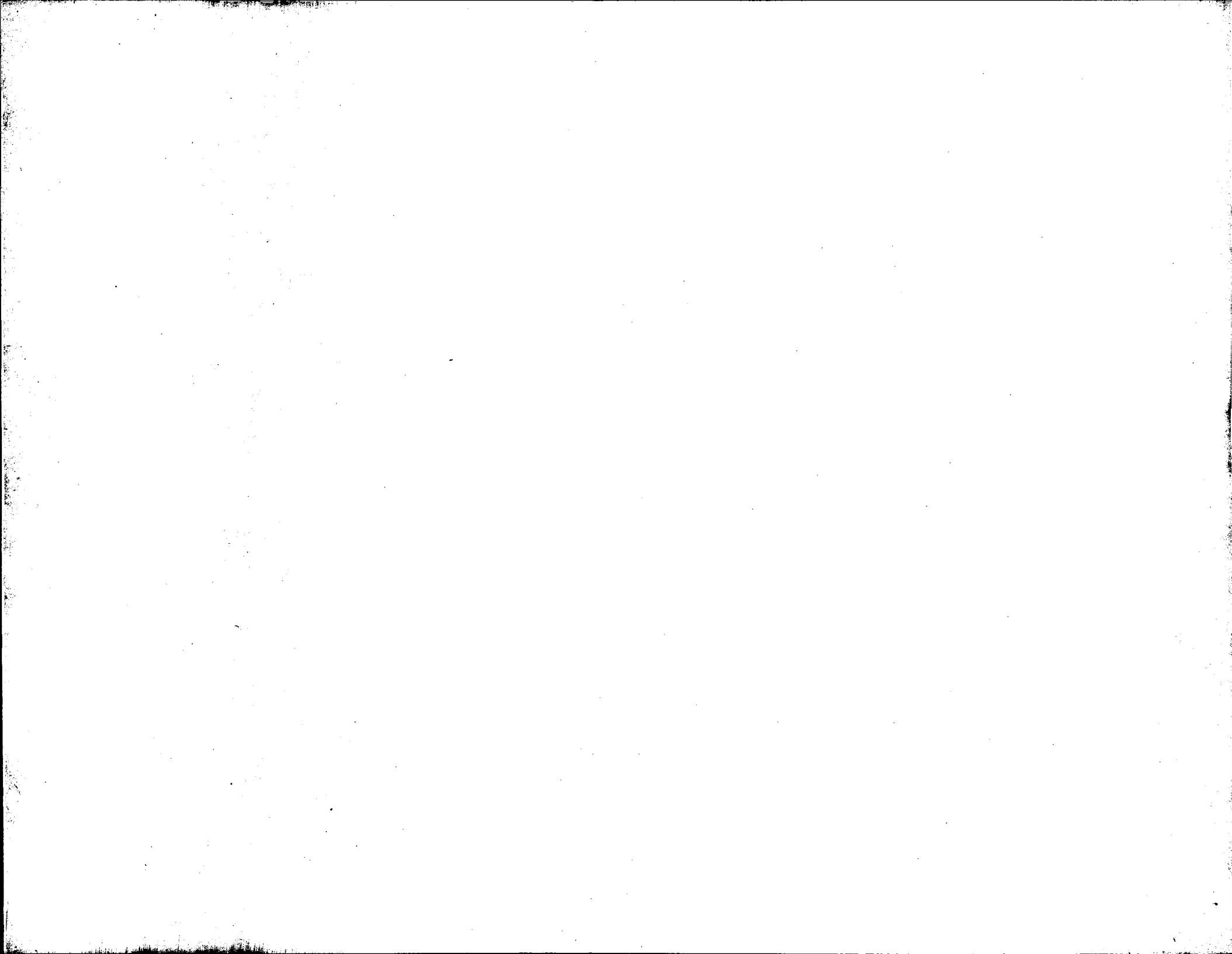
| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 25859 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.438 | 0.438 | 0.438 | 0.438 | | |
| B | 1.745 | 1.755 | | 1.745 | 1.746 | 1.746 | 1.745 | | |
| C | 3.495 | 3.505 | | 3.496 | 3.497 | 3.496 | 3.497 | | |
| D | 1.745 | 1.755 | | 1.745 | 1.746 | 1.746 | 1.745 | | |
| E | 7.990 | 8.010 | | 8.004 | 8.005 | 8.006 | 8.005 | | |
| F | 0.490 | 0.510 | | 0.492 | 0.493 | 0.493 | 0.493 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.375 | 0.375 | 0.375 | 0.375 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.501 | 0.502 | 0.501 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.178 | 1.178 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.564 | 0.563 | 0.563 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.178 | 1.178 | 1.177 | | |
| M | 1.490 | 1.500 | | 1.494 | 1.494 | 1.494 | 1.496 | | |
| N | 2.495 | 2.505 | | 2.495 | 2.495 | 2.496 | 2.495 | | |
| O | 3.869 | 3.879 | | 3.871 | 3.876 | 3.874 | 3.872 | | |
| P | 0.115 | 0.135 | | 0.128 | 0.128 | 0.128 | 0.127 | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.253 | 0.252 | 0.254 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.126 | 0.125 | 0.125 | 0.125 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.240 | 0.245 | 0.245 | 0.245 | | |
| W | 0.115 | 0.135 | | 0.120 | 0.118 | 0.118 | 0.119 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | 0.760 | 0.760 | | |
| Z | 0.352 | 0.372 | | 0.360 | 0.356 | 0.355 | 0.361 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.627 | 0.625 | 0.628 | 0.626 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.258 | 0.256 | 0.251 | 0.251 | | |
| AE | 1.375 | 1.395 | | 1.385 | 1.386 | 1.386 | 1.384 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.251 | 0.249 | 0.251 | 0.255 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.000 | 2.000 | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | EP | Audited by: | SD |
| Date: | 06/03/24 | Date: | 06.03.24 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |



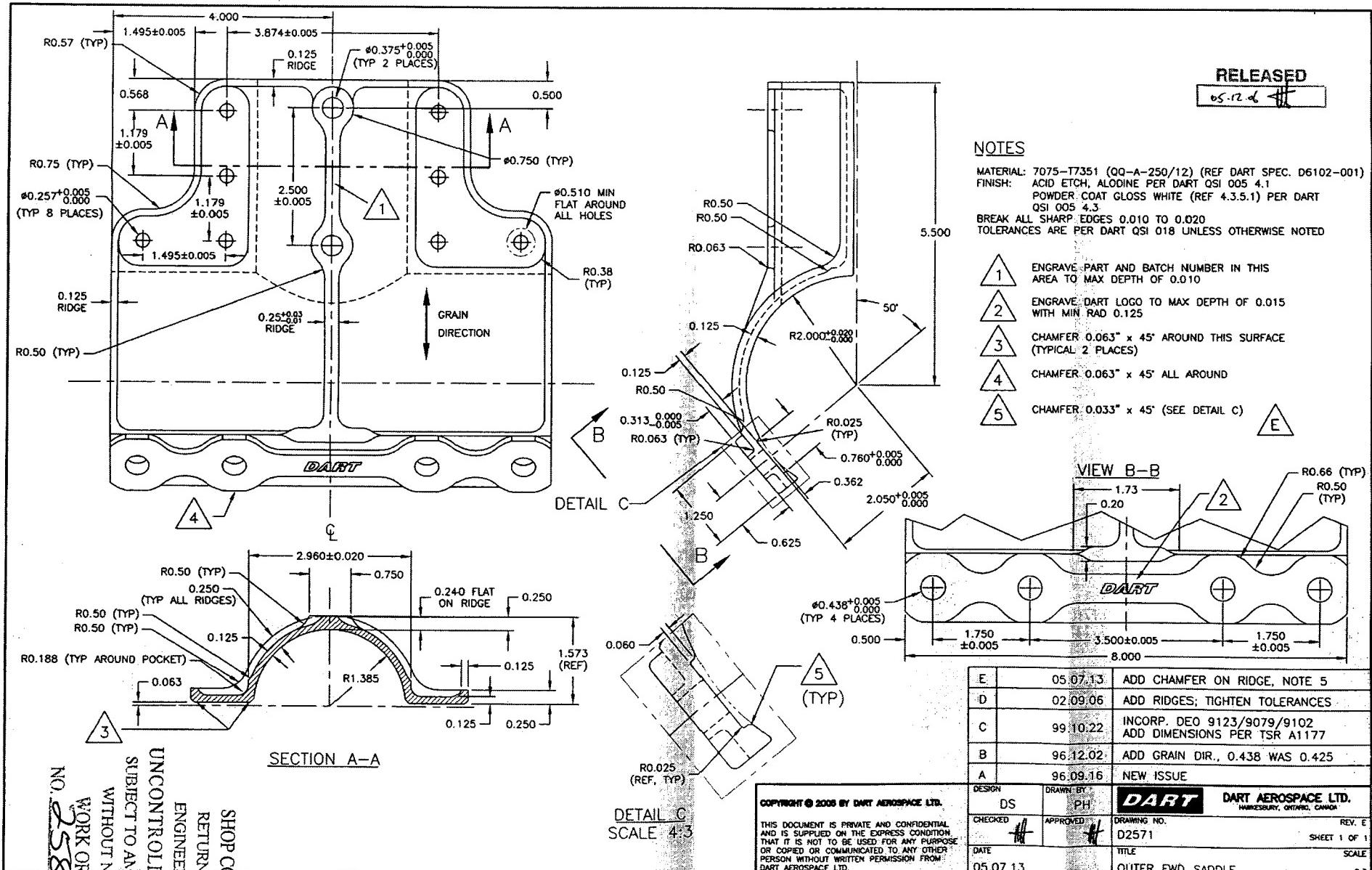
| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 25859 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.438 | 0.438 | | | | |
| B | 1.745 | 1.755 | | 1.745 | 1.747 | | | | |
| C | 3.495 | 3.505 | | 3.496 | 3.497 | | | | |
| D | 1.745 | 1.755 | | 1.745 | 1.746 | | | | |
| E | 7.990 | 8.010 | | 8.006 | 8.005 | | | | |
| F | 0.490 | 0.510 | | 0.500 | 0.501 | | | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | | | | |
| H | 0.375 | 0.380 | DT8684 | 0.375 | 0.375 | | | | |
| I | 0.490 | 0.510 | | 0.498 | 0.499 | | | | |
| J | 1.174 | 1.184 | | 1.178 | 1.179 | | | | |
| K | 0.558 | 0.578 | | 0.566 | 0.567 | | | | |
| L | 1.174 | 1.184 | | 1.178 | 1.179 | | | | |
| M | 1.490 | 1.500 | | 1.494 | 1.494 | | | | |
| N | 2.495 | 2.505 | | 2.498 | 2.499 | | | | |
| O | 3.869 | 3.879 | | 3.873 | 3.874 | | | | |
| P | 0.115 | 0.135 | | 0.128 | 0.127 | | | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | | | | |
| R | 0.240 | 0.260 | | 0.252 | 0.252 | | | | |
| S | 0.115 | 0.135 | | 0.125 | 0.124 | | | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | | | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | | | | |
| V | 0.230 | 0.250 | | 0.245 | 0.244 | | | | |
| W | 0.115 | 0.135 | | 0.118 | 0.118 | | | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | | | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | | | | |
| Z | 0.352 | 0.372 | | 0.366 | 0.360 | | | | |
| AA | 0.470 | 0.530 | | 0.560 | 0.560 | | | | |
| AB | 0.615 | 0.635 | | 0.625 | 0.627 | | | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | | | | |
| AD | 0.240 | 0.260 | | 0.252 | 0.252 | | | | |
| AE | 1.375 | 1.395 | | 1.386 | 1.386 | | | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | | | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | | | | |
| AH | 0.240 | 0.260 | | 0.254 | 0.254 | | | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | | | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | | | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | EN | Audited by: | SA |
| Date: | 06/03/25 | Date: | 06.03.26 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |



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